

# Work Order ID 54519

December 10, 2009 3:17:58 PM



Page 1

Item ID: D3179-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Litter Tie Down

Start Date: 10/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *RP*

Date: *09-12-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3179

Rev C

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.150" long

*SP 09/12/14*

*4*

*0*

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA297 Rev: *AA* & Dwg D3179-1 Rev: *C* □2-  
Deburr per dwg D3179-1

*mt 09/12/15*

*4*

*0*

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

*mt 09/12/15*

*4*

*0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54519**

December 10, 2009 3:17:58 PM



Page 2

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Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							
			Jmd/09-12-16		(4)	✓			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							
			mpd 09/12/17		xy				
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
			BL 09-09-12-17		(4)				

W/O:		WORK ORDER CHANGES					
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December 10, 2009 3:17:58 PM



Page 3

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Setup Start



Revision ID:

Stop



Item Name: Fwd Litter Tie Down

Start Date: 10/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 4.0



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

*M113170*

Memo

0.00

START TIME: *9:30*

DOVEN TEMPERATURE:

*BK09-12-17*

*(4)*

*3:00* FINISH TIME:

*10:00*

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

*JMP 09/12/17 24*

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per Dwg D3179

*9/30/12/21 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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December 10, 2009 3:17:58 PM



Page 4

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

SB 09/12/21

4

~~0~~

Quality Control

200

Identify as per dwg & Stock Location 225

0.00



Packaging

Memo

0.00

9/12/21

42 SP

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/12/22

Quality Control

CD 09/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



# Picklist Print

December 18, 2009 9:16:44 AM

Page 1

Work Order ID: 54519

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down




Start Date: 12/10/2009

Required Date: 12/18/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2372  Quick Release		Manufactured	No				Each	10.0000	8.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>41426</div> <div>Loc Qty</div> <div>10</div> <div>10</div> <div>Loc Code</div>												
D2444  Pip Pin Assembly		Manufactured	No				Each	11.0000	4.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>43978</div> <div>45387</div> <div>54533</div> <div>Loc Qty</div> <div>11</div> <div>1</div> <div>2</div> <div>8</div> <div>Loc Code</div>												
D6201  "T" Extrusion		Manufactured	No				f	20.0000	4.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>MAT</div> <div>45500</div> <div>Loc Qty</div> <div>20</div> <div>20</div> <div>Loc Code</div>												

8509/12/21

8

8509/12/21

1  
82

See  
Sheet 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 2

December 18, 2009 9:16:44 AM

Work Order ID: 54519

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down


Comments:

Start Date: 12/10/2009

Required Date: 12/18/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3  Nut		Purchased	No				Each	2,477.000	4.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2477	
110844	35	
111274	27	
111668	64	
112314	1851	
112385	500	

*Ep 509/12/21*

MS27039-I-13  Screw		Purchased	No				Each	109.0000	4.0000			
---	--	-----------	----	--	--	--	------	----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	109	
105211	9	
110844	100	

*Ep 509/12/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

December 18, 2009 9:16:44 AM

Work Order ID: 54519



Parent Item: D3179-041



Parent Item Name: Fwd Litter Tie Down

Start Date: 12/10/2009

Required Date: 12/18/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149D0332J

Purchased

No

Each

530.0000

12.0000



Washer

*9509/12/21*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

530

110625

16

110844

114

112794

200

113237

200

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

December 10, 2009 3:18:03 PM

Page 4

Work Order ID: 54519

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down

Comments:

Start Date: 10/12/2009

Required Date: 18/12/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2360 D6201-012		Manufactured	No				Each	0.0000	2.0000			
Litter Tie Down Assembly												
D3179-041		Manufactured	No				Each	5.0000	2.0000			
Fwd Litter Tie Down												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

45324

5

5

Each

4.0000

2.0000

D350-616-015

Manufactured No



Deck Plate

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FG031

44006

44640

4

1

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	54519
<b>Description:</b> Fwd Litter Tie Down Bracket		<b>Part Number:</b>	D3179-1
<b>Inspection Dwg:</b> D3179	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.000	—			
Ø0.242	+0.005/-0.001	Ø.243	—			
R0.40	+/-0.030	R.400	—			
0.375	+/-0.010	.362				extrusion size
Ø0.191	+0.005/-0.001	Ø.193	—			
1.00	+/-0.030	1.000	—			
1.70	+/-0.030	1.670	—			
4.00	+/-0.030	3.770	—			
1.50	+/-0.030	1.500	—			
0.750	+/-0.010	.748	—			
1.50	+/-0.030	1.500	—			
10.500	+/-0.010	10.500	—			
4.250	+/-0.010	4.247	—			
0.750	+/-0.010	.748	—			
1.000	+/-0.010	1.000	—			
12.00	+/-0.030	12.000	—			
1.00	+/-0.030	1.000	—			
8.00	+/-0.030	8.000	—			
Ø0.191	+0.005/-0.001	Ø.192	—			
R0.37	+/-0.030	R.370	—			
0.97	+/-0.030	.966	—			
1.86	+/-0.030	1.866	—			
1.750	+/-0.010	N/A				Inspected 09.12.15
0.375	+/-0.010	.366	—			
2.875	+/-0.010	2.873	—			
0.500	+/-0.010	.497	—			
1.250	+/-0.010	1.257	—			
1.625	+/-0.010	1.628	—			
3.31	+/-0.030	3.306	—			

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	<i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09/12/15	<b>Date:</b>	09.12.15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue	P/O D3179-041	KJ/DD <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

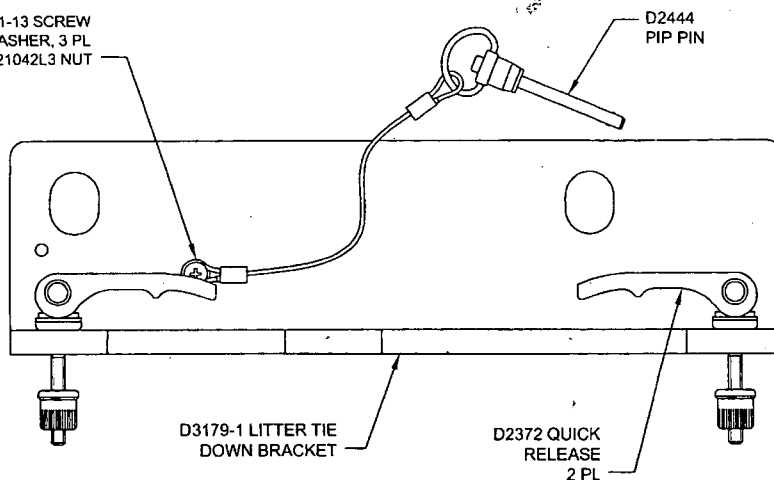
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

MS27039-1-13 SCREW  
NAS1149D0332J WASHER, 3 PL  
MS21042L3 NUT



**D3179-041 FWD LITTER TIE DOWN BRACKET**

**NOTES:**  
1) D3179-041 WEIGHT: 2.79 lbs

Item	Qty	Part Number	Description
1	X	D3179-041	FWD LITTER TIE DOWN
2	2	D2372	QUICK RELEASE
3	1	D2444	PIP PIN
4	1	D3179-1	LITTER TIE DOWN BRACKET
5	1	MS21042L3	NUT
6	1	MS27039-1-13	SCREW
7	3	NAS1149D0332J	WASHER (OR AN960JD10L)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54519  
*BS 09-12-10*

**RELEASED**  
*08/11/21 MJB*

C	ADD D3179-041 & PART LIST (ZN B6-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N	RF	08.11.07
B	REFORMAT DRAWING, FINISH WAS ANODIZE	DC	07.06.06
A	NEW ISSUE	RF	02.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3179	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

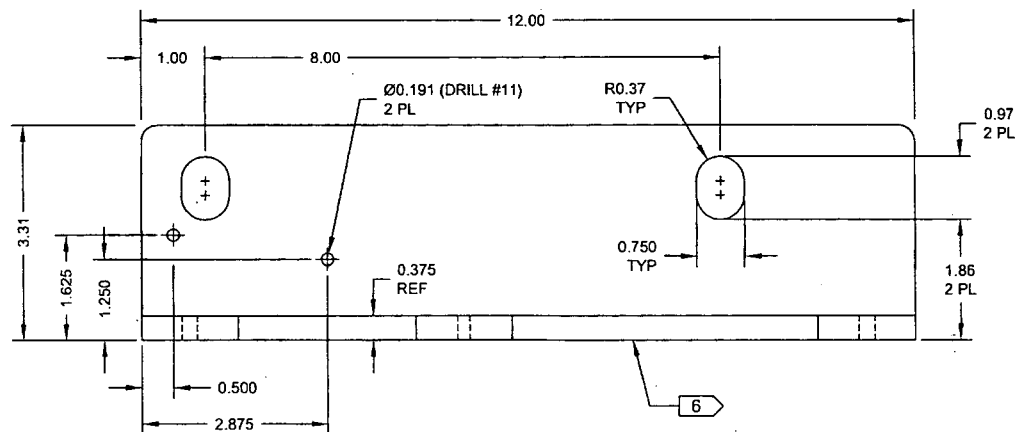
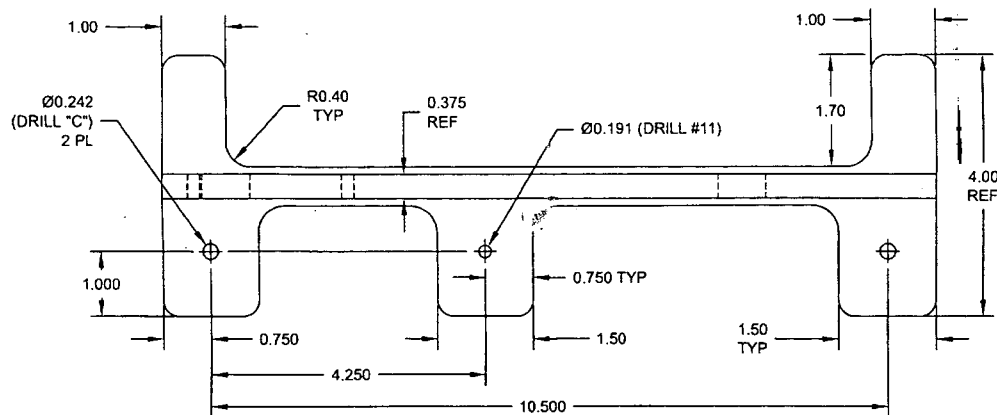
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**D3179-1 LITTER TIE DOWN BRACKET**

**NOTES:**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3179-1 USING FINE POINT PERMANENT INK MARKER ON THE BOTTOM FACE
- 7) WEIGHT: 2.3 lbs

**LEASED**  
08/11/07

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.		D3179	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8

7

6

5

4

3

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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